

Work Order ID 61475

Thursday, August 26, 2010 2:39:38 PM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 8/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-8-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

0.00

100



DOCUMENT CONTROL

0.00

DC

Document Control

Memo

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Required Date: 9/6/2010 Req'd Qty: 1.00

Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------------|--------------|---------------|---------------|------------------|----------------|
| 110 | HandFinishing | 0.00 | | | | | | | |
| Hand Finish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/R <input type="checkbox"/> Sikaflex-241/-291 <input type="checkbox"/> M115114 Expiry date: <input type="checkbox"/> 11/01 | | | 27M 10/08/31 | | 1 | 0 | | |
| | 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/R <input type="checkbox"/> Sikaflex-241/-291 <input type="checkbox"/> M115114 Expiry date: <input type="checkbox"/> 11/01 | | | | | | | | |
| | 3-Remove "T" pins once sikaflex is dry. | | | | | | | | |
| | 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R <input type="checkbox"/> LPS Procyon <input type="checkbox"/> M114594 | | | | | | | | |

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Required Date: 9/6/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | ml | 10 | 02 | 01 ① |
| Quality Control | | | | | | | | | |
| 130 | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D412-742-043 | | | | | | | | |
| | Location: _____ | | | | | | | | |
| | PPP Rev: _____ | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Ca 10/9/10

10/09/10
mf
10-9-03

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61475

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube



Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| AN3C4A | | Purchased | No | | | 110 | Each | 1,769.000 | 24 | 24 | | | |
| BOLT | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST303 | 500 | |
| 115438 | 500 | |
| ST350 | 1269 | |
| 114108 | 14 | |
| 114416 | 12 | |
| 114523 | 2 | |
| 114941 | 241 | |
| 115300 | 1000 | |

x24 JH 10/08/31

| | | | | | | | | | | | | | |
|------------|--|-----------|----|--|--|-----|------|----------|----|----|--|--|--|
| AN3C6A | | Purchased | No | | | 110 | Each | 361.0000 | 12 | 12 | | | |
| BOLT | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST351 | 361 | |
| 111982 | 361 | |

x12 JH 10/08/31

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Page 2

Work Order ID: 61475

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 174.0000 8 8



BOLT



Location Loc Qty Loc Code

ST351 174
105906 4
107376 4
113149 121
114382 45

x8 JH 10/08/31

AN960C10L NAS1149C0332 Purchased No 110 Each 155.0000 44 44



washer



Location Loc Qty Loc Code

ST245 155
107534 29
109545 54
111548 72

1115000

x44 JH 10/08/31

D3391-021 Manufactured No 110 Each 0.0000 1 1



Fwd Tube Assembly

D3391-023



Mid Tube Assembly

Manufactured
A.

No

pulled on
D3391-023
B56621

B56494

x1 JH 10/08/31

Manufactured

No

110 Each 1.0000 1 1

Location Loc Qty Loc Code

FP 1
40522 1

B56621

x1 JH 10/08/31

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Shop Packet Print

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Work Order ID: 61475

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3391-025

Manufactured No

110 Each

1.0000

1

1



Aft Tube Assembly



1356500 x1 10/08/13

Location

Loc Qty

Loc Code

FP

1

48122

1

D3564-1

Manufactured No

110 Each

17.0000

1

1



Wearshoe



Location

Loc Qty

Loc Code

FG

2

33798

2

FP

3

51676 *

3

FP19

12

58823

12

D3564-3

Manufactured No

110 Each

16.0000

1

1



Wearshoe



Location

Loc Qty

Loc Code

FG

2

33764

2

FP19

14

55489

2

58825

12

x1 10/03/13

x1 10/03/13

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Shop Packet Print

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Page 4

Work Order ID: 61475

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

110

Each

20.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

17

59157

6

60868

11

X1 M 10/03/31

D3566-1

Manufactured No

110

Each

27.0000

2

2



Gasket

Location

Loc Qty

Loc Code

FP

3

60857

3

FP015

24

57715

2

60202

12

61215

10

X2 M 10/03/21

D3566-5

Manufactured No

110

Each

29.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

22

60869

22

FP015

7

59158

7

X1 M 10/03/31

Thursday, August 26, 2010 2:39:42 PM

Shop Packet Print

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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

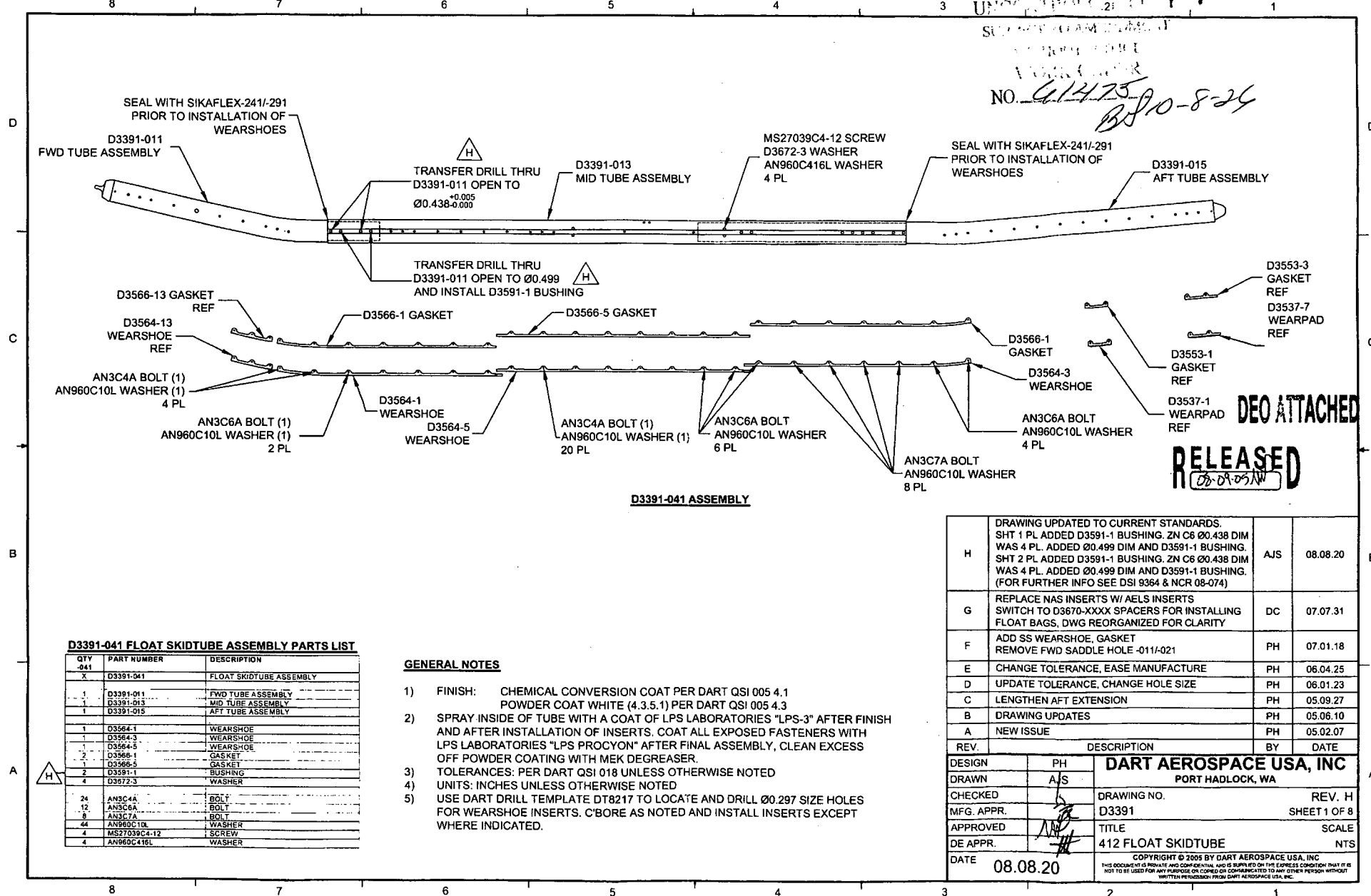
FROM

UNCONTROLLED COPY

SUPPLY TEAM PLANNED

WORK ORDER

NO. 61475
BS10-8-25



DEO ATTACHED

RELEASED
08-09-25 NW

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|-------------------------|
| 1 | D3391-041 | Float Skidtube Assembly |
| 1 | D3391-011 | FWD Tube Assembly |
| 1 | D3391-013 | MID Tube Assembly |
| 1 | D3391-015 | AFT Tube Assembly |
| 1 | D3564-1 | WEARSHOE |
| 1 | D3564-3 | WEARSHOE |
| 1 | D3564-5 | WEARSHOE |
| 2 | D3566-1 | GASKET |
| 1 | D3566-5 | GASKET |
| 2 | D3591-1 | BUSHING |
| 4 | D3572-3 | WASHER |
| 24 | AN3C4A | BOLT |
| 12 | AN3C6A | BOLT |
| 8 | AN3C7A | BOLT |
| 44 | AN960C10L | WASHER |
| 4 | MS27039C4-12 | SCREW |
| 4 | AN960C416L | WASHER |

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

| REV. | DESCRIPTION | BY | DATE |
|------------|---|--|----------|
| H | DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074) | AJS | 08.08.20 |
| G | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY | DC | 07.07.31 |
| F | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021 | PH | 07.01.18 |
| E | CHANGE TOLERANCE, EASE MANUFACTURE | PH | 06.04.25 |
| D | UPDATE TOLERANCE, CHANGE HOLE SIZE | PH | 06.01.23 |
| C | LENGTHEN AFT EXTENSION | PH | 05.09.27 |
| B | DRAWING UPDATES | PH | 05.06.10 |
| A | NEW ISSUE | PH | 05.02.07 |
| DESIGN | PH | DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3391 TITLE 412 FLOAT SKIDTUBE SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |
| DRAWN | AJS | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.08.20 | | |

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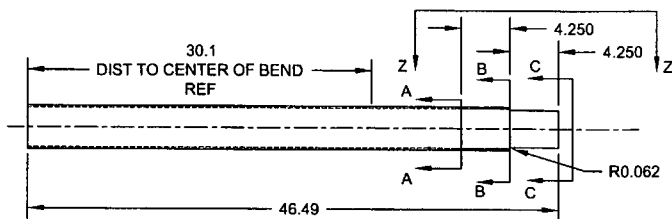
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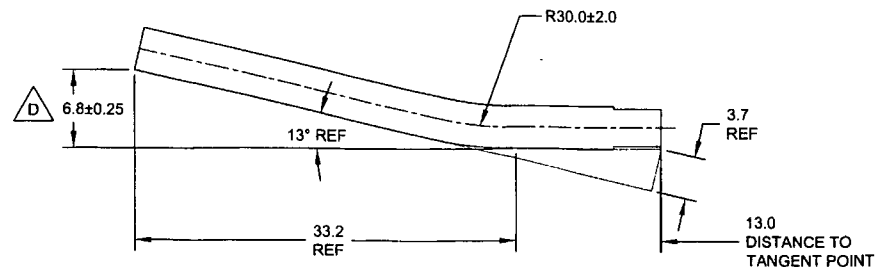
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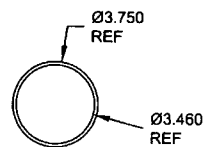
NOTE: Date & initial all entries



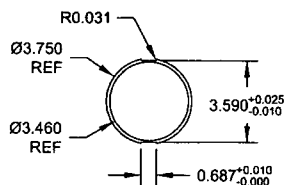
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



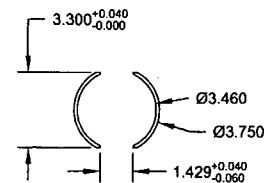
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



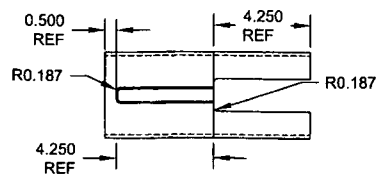
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
28 JAN 75

| | | | |
|---|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D3391 | SHEET 3 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
| DATE | 08.08.20 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC | |
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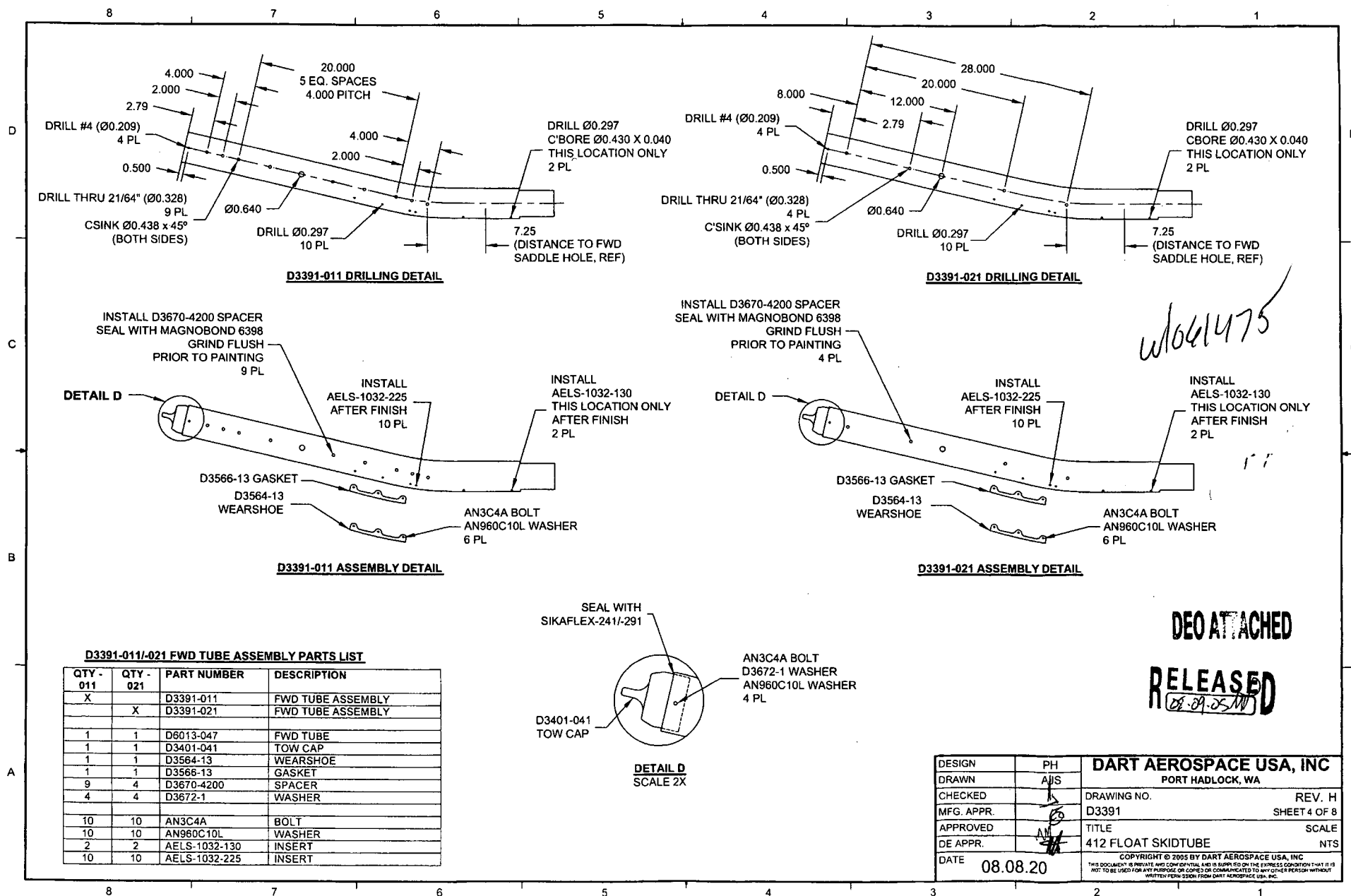
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



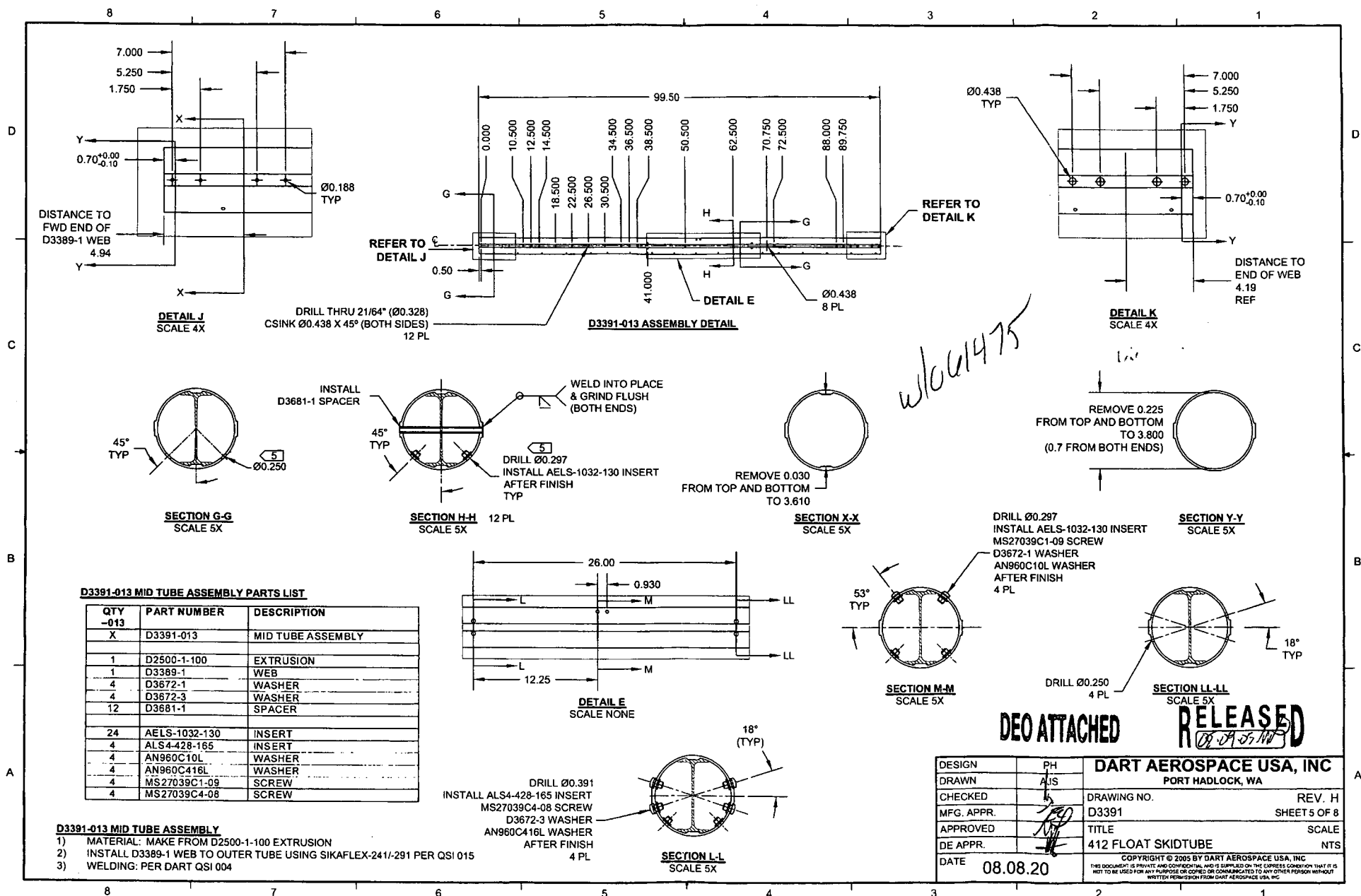
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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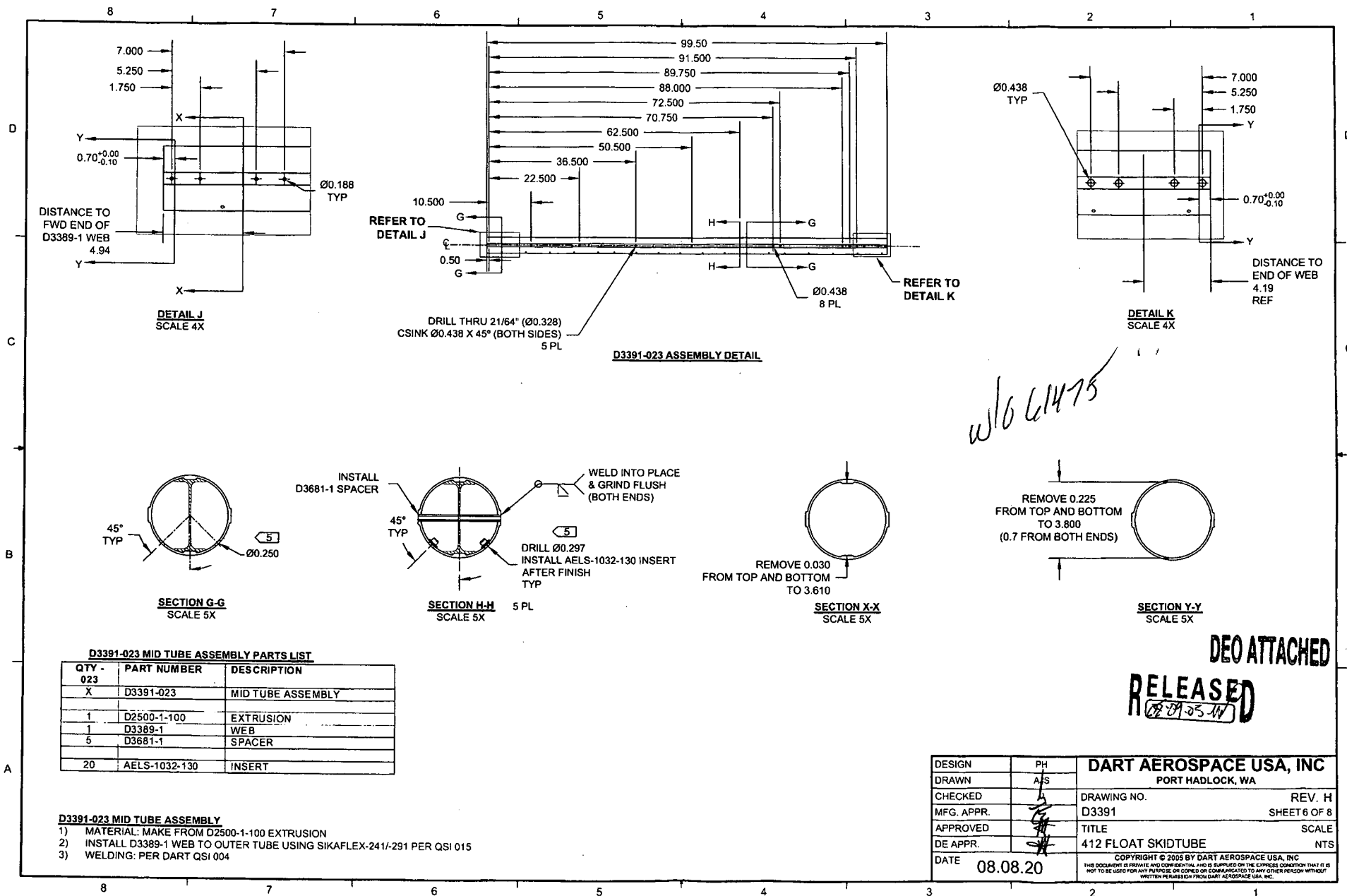
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NOTE: Date & initial all entries

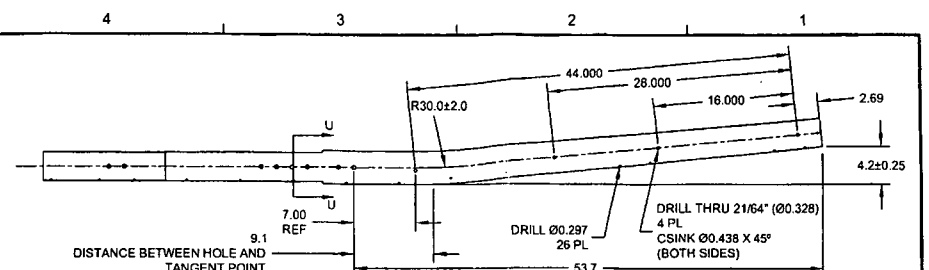
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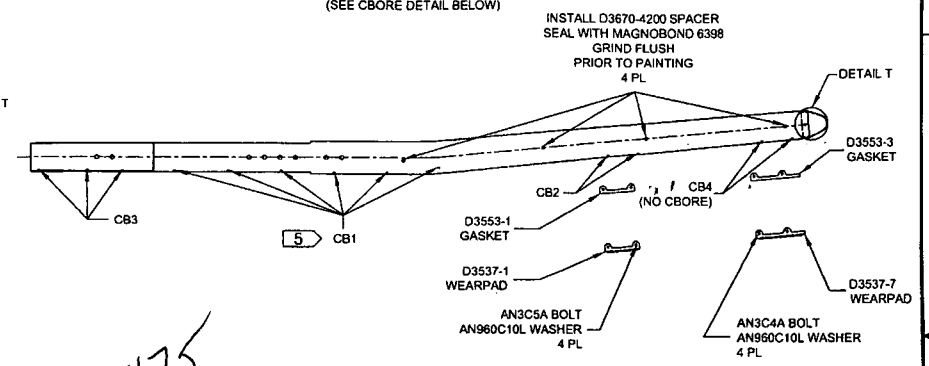
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NOTE: Date & initial all entries

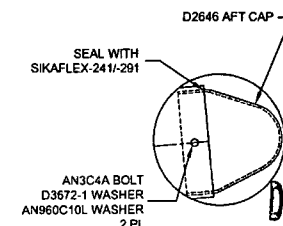


D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



DEO ATTACHE

RELEASED
08-09-05

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | CBORE | P/N |
|--------------|------------------|------------------|----------------|---------------|
| CB1 | 12 | 12 | Ø0.430 X 0.170 | AELS-1032-225 |
| CB2 | 4 | 4 | Ø0.430 X 0.170 | AELS-1032-130 |
| CB3 | 6 | 6 | Ø0.430 X 0.040 | AELS-1032-130 |
| CB4 | 4 | 4 | NONE | AELS-1032-130 |

| | | | |
|---------------|--------------------|--|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AS | PORT HADLOCK, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. H |
| MFG. APPR. | <i>[Signature]</i> | D3391 | SHEET 8 OF 8 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 412 FLOAT SKIDTUBE | NTS |
| DATE 08.08.20 | | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR CONDUCT NOT AUTHORIZED BY ANY OTHER PERSON OR ENTITY. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|----------------------|-----------------------------|-------------------------|--|-------------------------|-------------------------|---------------------------|--------------|
| DRAWING NO. D3391 | TITLE 412 FLOAT SKIDTUBE | REV. H | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D3391-H-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>UP</i> | CHECKED <i>h</i> | MFG. APPR. <i>h</i> | APPROVED <i>MP</i> | DE APPR. <i>h</i> | | | |
| DATE 09.09.23 | DATE <i>09.09.24</i> | DATE <i>09/09/25</i> | DATE <i>09/09/30</i> | DATE <i>09/09/30</i> | | | |

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

w/o 6/14/75

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